

Date: Monday, 8/13/2007 2:14:59 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD
Job Number	: 33881			
Estimate Number	: 12711			
P.O. Number	: N/A		Part Number	: D35373
This Issue	: 8/13/2007 S.O. No. : N/A		Drawing Number	: D3537 REV C
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A		Drawing Revision	: C
Previous Run	: 33285		Material	: N/A
Written By	<u>JLM 07-08-13</u>		Due Date	: 8/20/2007
Checked & Approved By			Qty:	60 Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
		Comment: Qty.: 0.1512 sf(s)/Unit Total : 9.0720 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: N105130	SAP 07/08/13
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C	2-Deburr if necessary SAP 07/08/13 60
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAP 07/08/13 60
4.0	QC8	SECOND CHECK	 <i>cauter</i>
		Comment: SECOND CHECK	En 07/08/14 60
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158	SB 07/08/22 SB 07/08/23 <i>60</i> <i>60</i>

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Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



coated

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Encl 08/23

x60

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
AVR 2059B Hardcoat M105315 / 14105465
Weld hardcoat as per Dwg D3437

07/09/10

60x

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/07/09/11 (60)

10.0 POWDER COATING

POWDER COATING



M104846

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11/07/09/11 (60)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ml 07 09 12

(60)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: F.P.

ml 07 09 12

(60)

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/07/09/13

13

Job Completion



11/07/09/13

DART AEROSPACE LTD	Work Order:	338P
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537 Rev: C		Page 1 of 1

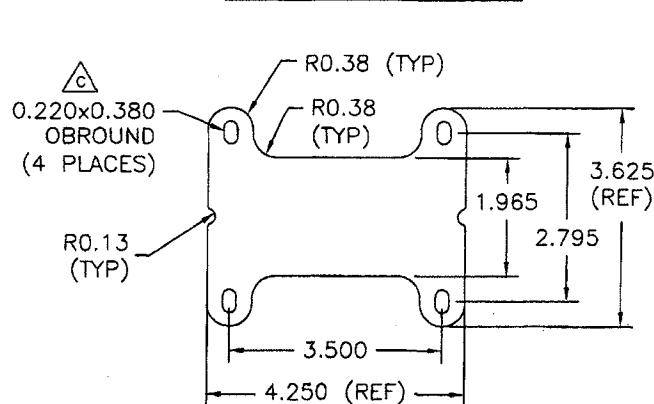
FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

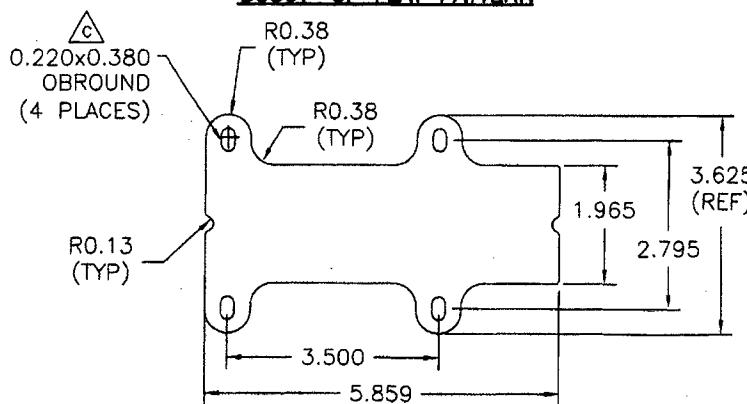
Measured by:	SAD	Audited by:	EN	Prototype Approval:	N/A
Date:	07/08/13	Date:	07/08/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

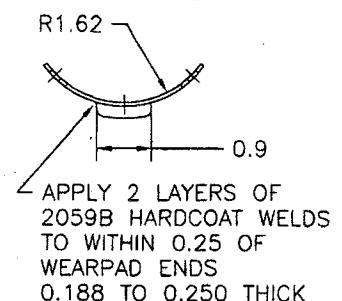
D3537-1F FLAT PATTERN



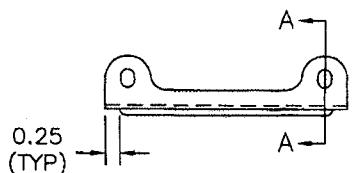
D3537-3F FLAT PATTERN



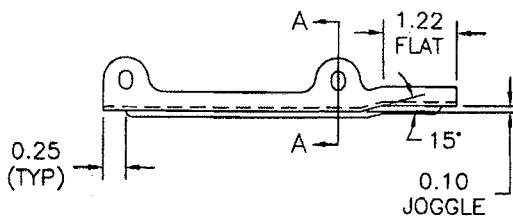
SECTION A-A



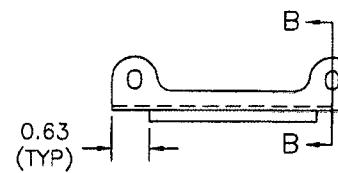
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)

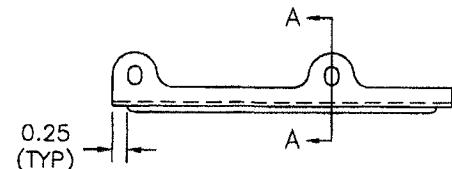


D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



RELEASED
07.05.08 AM
PER E&LN
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DRAWN BY	CB AH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. C D3537
DATE		SHEET 1 OF 1 TITLE WEARPAD SCALE 1:2
07.04.13		